Packaging

B 100 463

*100463

Page 1

April-22-13 1:41:01 PM Accept *N900040100* D4148-041 Setup Start Item ID: Revision ID: Item Name: Crosstube Lug Assembly, Fwd **Start Date:** 5/09/13 Start Otv: 6.00 **Cust Item ID:** Required Date: 5/09/13 Rea'd Otv: 6.00 Customer: Reference: Run Process Plan: MLJ Date: /3-04-25 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Code Qty . Qty Number Stamp Work Center ID Description **Run Hours Revision Nbr** Draw Nbr D4148 D 0.00 100 *100* 0.00 Small Fab Memo 1- Assemble as per dwg Small Fab OC5- Inspect part completeness to step on W/O *110* 0.00 13 7 0 Memo Quality Control Identify as per dwg & Stock Location 120 *120* 0.00 Packaging Memo

									DQA:	Da	te:	
NCR: Y	es / No			WORK ORDER NON-C	CON	IFORI	MANCE / UPI	DATE	QA Closed:	Da	te:	
Work Orde		*	·	DISPOSITION				AGAINST DI	EPARTMENT/	PROCESS		
Part N	0			Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root Cause	Date	Step	Qty	ption of work order update or Non-conformance	1	nitial ief Eng		ion ription	Sign & Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Jeep	aty .	·								
				 F	AUL	T CATE	GORY					
Landir	Bending Centre N Cracks Crushed Cuffs Heat Tre Inspection Ripples in Torque V	/Crimped at on Strip in n Bend Vaves in I	ı Tube Extrusio	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misreae Offset Out of	ion Incomplete tions Incomplete/U enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	T v	ressure/Forced emperature/Cure /eld /rong Stock Pulled hther
	Wave/Tv			Folio		1	Dimensions					

Work Orde		00463		*100	1463*					Page	2
Item ID: Revision ID: Item Name:	D4148-041 Crosstube L	l .ug Assembly, Fwd		Accept	*N900	040	100)* s	Setup Star Stop	14.21	
Start Date: Required Date: Reference:	5/09/13 5/09/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					
Approvals:	Process P	Plan:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Star Stop	"INK1"	
Sequence ID/ Work Center II 130 *120* QC)	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp	-

Pl 13-07-11

											DQA:	Date:	
NCR:	es /	No No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		·		
											QA Closed:	Date:	
Work Orde	ar.		•			DISPOSITION			AGA	INST DE	PARTMENT,	PROCESS	
WOIK OIG	- · · ·					Rework	7		Skid-tube Cross	tube		Water Jet	Engineering
Part N	No.					Scrap	1		—	l Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1	6		shing		e/Packaging	Other
NCR N	No.					Work Order Update	1		~ 	osite		Supplier	
	_					, <u> </u>				<u> </u>			لـــــا
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data	Ц												
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Operator													
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Process					ĺ								
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	Шc	entre No	ot Concer	ntric to	o/s	BOM/Route	L	Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	Щc	racks				Broken/Damaged		Inspecti	on incomplete		Part Incorred	t	Weld
	Crushed/Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled		
	∐]c	uffs				Contamination		Mainte	nance		Part Moved		
	Crushed/Crimped Cuffs Heat Treat					Countersink		Mislabe	led	Γ	Positioned V	/rong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-22-13 1:41:00 PM

Work Order ID:

100463

Parent Item:

D4148-041

Parent Item Name:

Crosstube Lug Assembly, Fwd

Start Date: 5/09/13

Required Date: 5/09/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

DD_verf:EC

EVB DD verf:JLM IPP Rev:C 10.10.29 as per revC IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	2,388.0000	4	12		3,	
Nut							_		6,····································	rature same consistent	Je	///	10_F
				Location		Loc Qty		oc Code					
				FG		80							
					3691	80							
				GA		106							
					3899	106			-				
				ST315	•••	2202							
					3899 4555	196 2006				$\overline{}$		_ /	j
MS21043-4		5 1 1	No	12	4333	100	Each	439.0000		-			
Nut		Purchased	NO			100	Lacii	437.0000	.1	18		1/3	67
INUL								6.1	 				
i.				<u>Location</u>		Loc Oty		oc Code					
				FG		36				/	•		
					4603	36							
:				GA		44							
•					1652	44						. ~~	~~
				ST315		359					Μ	125	8Q7
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NCR: Y	'es /	No				WORK ORDER NON-C	O	NFORN	/ANCE / UP	DATE				
											QA Close	d:	Date	•
Work Orde	s ŕ .					DISPOSITION		·		AGAINST DE	PARTMEN	IT/PRO	CESS	
Part N						Rework Scrap Use-as-is		Ţ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	1	rod. En	ater Jet g. Coor. ckaging	Engineering Quality Other
NCR N	lo				<u></u>	Work Order Update			Large Fab	Composite			Supplier	
Root						ption of work order update	l .	nitial		tion	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Ve	rification	QC Inspector
Doc/Data	_													
Equip/Tooling														
Operator			·											
Material					 									
Setup	\Box					:								
Other	Ц				į									
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Supplier	Щ													
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Landi					_	General	_	7			,		_	- 1
	$\boldsymbol{\vdash}$	ending			<u> </u>	Bend	<u></u>	Grain			Ovalized			Pressure/Forced
	—	entre No	t Concer	ntric to	o/s	BOM/Route	<u></u>	Hardwa			Over/Und		ance	Temperature/Cure
	—	racks			<u> </u>	Broken/Damaged	\vdash	4	on Incomplete		Part Incor		_	Weld
•	$ldsymbol{}$	rushed/0	Crimped			Burrs	<u></u>	-	ions Incomplete/	'Unclear	Part Lost/	_		Wrong Stock Pulled
	∐c	uffs				Contamination	ļ	Mainte		<u></u>	Part Mov			
	Щн	leat Trea	t			Countersink		Mislabe	eled		Positione	d Wrong	· _	_
	Ir	nspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Lo	ss/Surge	·	Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio Picklist Print
April-22-13 1:41:00 PM

Work Order ID: Pårent Item:	100463 D4148-041					Start	Date: 5/09/13	Required Date: 5/09/13
L. Fr.	Crosstube Lug Assembly, Fwd						t Qty: 6.00	Required Qty: 6.00
D2690-6		No		100	Each	33.0000	1	
Lanyard Assembly	Manufactured	No		100	Each	33.0000	1	6 3/07/10
Lanyard Assembly		T -	<u>cation</u>	Loc Qty		Loc Code		
						Loc Code		2 14176 A
	,	· ST		33				-
			94775 95935	9				_
•			98482	3				_
			99056	10				
			99808	10				
D3910-1	Manufactured	No		100	Each	8.0000	1	-6 <i>f</i> // - / / /
Crosstube Lug	Manufactured						**************************************	1/13/07/10
		Lo	<u>cation</u>	Loc Qty		Loc Code		
		ST-		8		201 0040		
		31	81474	2		~.		B(00342) 6x
			89772	1				
			93755	5				$=$ ρ_{I} I I
D4091-1	Manufactured	No		100	Each	21.0000	1	6 // 2/-/
Mounting Lug	Transactur ea						0	() (3/07/10
		Lo	<u>cation</u>	Loc Qty		Loc Code		
7		ST	•	21				1 B100346 (Gx)
		51	97517	21				Dissila
D4148-1	Manufactured	No	,,,,,,	100	Each	6.0000	2	12
Crosstube Lug Plate, Fwd		110			<u> </u>	0.0000		1//)(3/07/10
Clossiate Eug Flate, Fwa		T		Loc Qty		Loo Codo		4
			<u>cation</u>			Loc Code		B100297 (1
		81	145	6				- DIOUETA
			85753 97907	2				B102771 (11
D4140.2	34 6	No	97907	100	Each	14.0000	1	- B102771 (1)
D4148-3 Stud Receiver, Lower	Manufactured	No		100	Lacii	14.0000	1	0/10/10/10
Stud Receiver, Lower		_						707/10
		·	<u>cation</u>	Loc Qty		Loc Code		<i>'</i>
		ST	145	14				- 7100574
			97610	8				B/00534
			97611	6				- <i>(6×)</i>
April-22-13 1:41:01	! PM		Shop	Packet Print				Page 2

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	ANCE / UPD	ATE			
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	•					Rework Scrap		ľ	Skid-tube Machining	Crosstube Small Fab	ł	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Ī	Initial	Actio	on	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data	Ш					•							
Equip/Tooling	Ш						İ						
Operator	Ш				l i]		
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Supplier	<u></u>	į									1		
Training							1						
Unapproved			<u> </u>		<u> </u>		1_						
							AUI	LT CATE	GORY	***************************************			
Land	ing (1			_	General	_	1			1	[٦_ ,
ļ	<u> </u>	Bending				Bend	\vdash	Grain		<u> </u>	Ovalized		Pressure/Forced
	\vdash	Centre N	ot Conce	ntric to	O/S	BOM/Route	<u> </u>	Hardwa			Over/Under	 	Temperature/Cure
	<u> </u>	Cracks			-	Broken/Damaged	1	4 '	on incomplete	_	Part Incorre		Weld
	Crushed/Crimped			Burrs	\perp	4	ions Incomplete/Un	nclear	Part Lost/M		Wrong Stock Pulled		
	Cuffs			Contamination	_	Mainte			Part Moved				
	\perp	Heat Tre	at			Countersink		Mislabe	eled		Positioned \		7
	1	Inchartic	n Strin in	Tuha	1	Cut Too Short	1	Microan	4		Power Loss	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-22-13 1:41:01 PM

Work Order ID:	100463								
Parent Item:	D4148-041						Start	Date: 5/09/13	Required Date: 5/09/13
Parent Item Name:	Crosstube Lug Ass	embly, Fwd					Start	Qty: 6.00	Required Qty: 6.00
D4148-5 Eyebolt Stud		Manufactured	No		100	Each	13.0000	1	2/3/07/10
·	·	• .		Location	Loc Qty		Loc Code		B102/12 (
				ST145	13				161197
				97587	1				
				99176	12				
AN3C12A		Purchased	No		100	Each	208.0000	2	12
Bolts									
				Location	Loc Qty		Loc Code		
				ST351	208				_ /
				123648	5				_
				124561	201			_12_	- /
				124858	2				- ///////
AN4C13A		Purchased	No		100	Each	128.0000	3	18/3/62/
BOLT					•				
				Location	Loc Qty		Loc Code		
				ST356	3				
				123900	3				- MIDI 193
				ST514	123				
				124805	123				- ' (18x)
				ST516	2				
				124215	. 2				- ()/ /
M\$17984-C413		Purchased	No		100	Each	15.0000	1	6
PIN, QUICK RELEASI	€							4.0	- C/3/07/10
				Location	Loc Qty		Loc Code		
				ST332	. 2				1 11 125877
				118612	2				N 125827
				ST508	13				
				124231	13			-	- (6,5)

NCR:	⁄es	/ No				WORK ORDER NON-	CON	IFORN	MANCE / UPI	DATE			
											QA Closed:	Date	:
Work Orde	er: _					DISPOSITION				AGAINST DE	PARTMENT		
Part N	•					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	3	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root		<u> </u>			Descri	ption of work order update	Ti	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						F	AUL	T CATE	GORY				
Landi	ng G	iear			·	General							
		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	ı Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	et ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
l	1	Torque V	Vaves in I	Extrusio	n I	Drawing	1	Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

April-22-13 1:41:01 PM

Work Order ID:	100463						7/00/110	
Parent Item:	D4148-041						ate: 5/09/13	Required Date: 5/09/13
Parent Item Name:	Crosstube Lug Assembly, Fwd					Start (Qty: 6.00	Required Qty: 6.00
MS20615-4M18 Rivet	Purchased	No		100	Each	219.0000	8	48 / 33/07/
		Lo	cation	Loc Qty		Loc Code		
		GA		7				- 150
			122452	7				_ U175679
		ST	312	212				- ///
			124331	115				480
			125162	97				- OIT
NAS1149C0332R Washer	Purchased	No		100	Each	7,451.0000	4	24 /3/07
		<u>Lo</u>	cation	Loc Qty		Loc Code		
		FP	100	264				_
			123355	264				_
		ST	292	4309				_
			123248	18				
			123759	2801				_
			125268	1490				_
		SI	517 124580	2878 2878			21	- / /
14 C11 40 C0 422D	D 1	No	124380	100	Each	1,686.0000	- 2 -	$\frac{1}{36}$
NAS1149C0432R Vasher	Purchased	INO		100	Each	1,080.0000		30 (13/07)
		<u>L</u> c	cation	Loc Qty		Loc Code		
		ST	292	1686				_/
			119124	6				_
			122441	1680				_
						,	M1758	707 (2Cx)
						4	(12)0	$\mathcal{L}_{\mathcal{L}}}}}}}}}}$

											DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-C	ON	IFORN	MANCE / UPI		QA Closed:	 Date:	
Work Orde	er:			,		DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	-		-			Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	- lo	ś	*			Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root	-{				Descri	ption of work order update	1:	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data					,								
Equip/Tooling													
Operator				ĺ									
Material						·							
Setup													
Other				 							,		
Process					·	-	İ						
Supplier													·
Training													
Unapproved													
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Landi	ng G	iear			_	General	_	1			1		1
	Ш	Bending				Bend		Grain		·	Ovalized		Pressure/Forced
		Centre No	ot Concei	ntric to	O/S	BOM/Route		Hardwa	re	.	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	\Box	Inspecti	on incomplete		Part Incorre	}	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	ending entre Not Concentric to O/S racks rushed/Crimped uffs			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

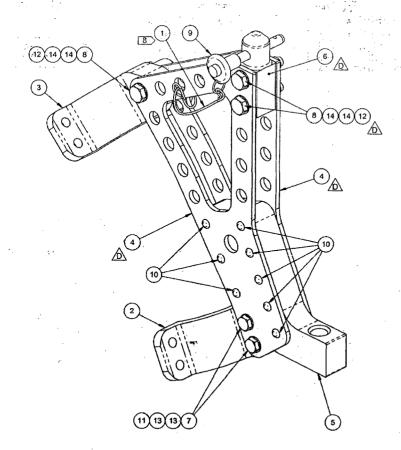
Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio



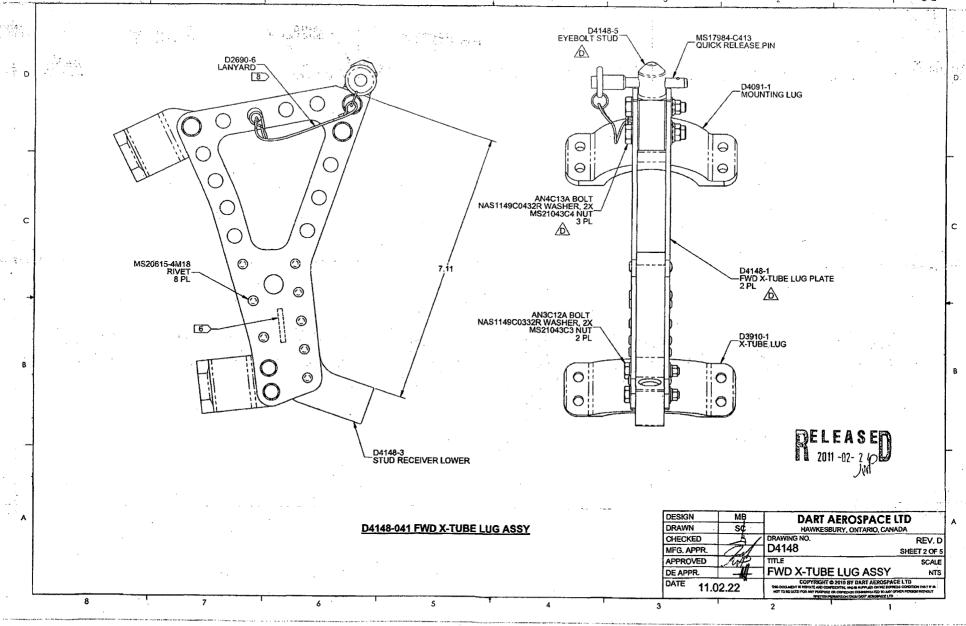
D4148-041 FWD X-TUBE LUG ASSY

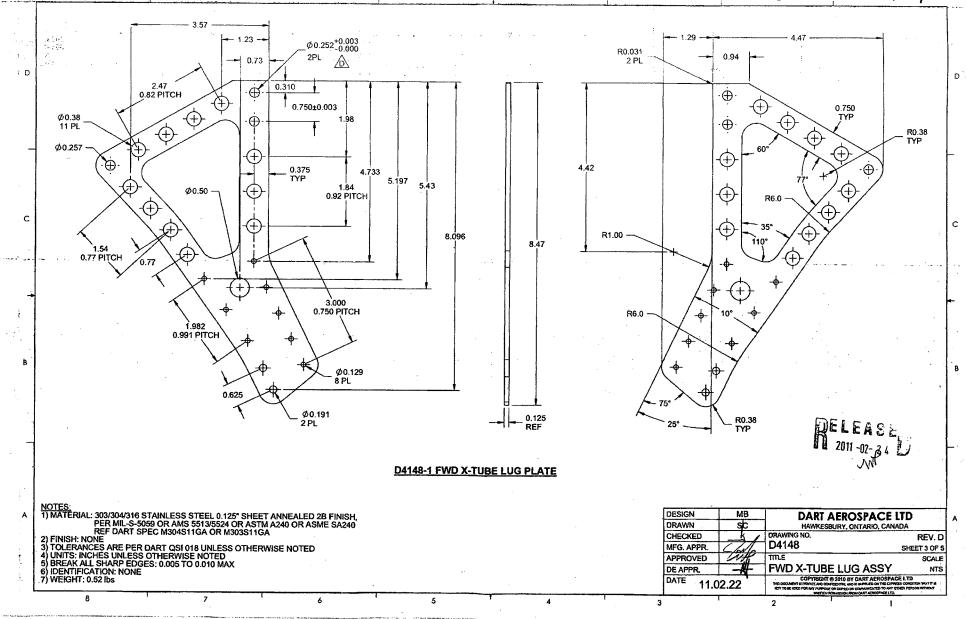
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
7) WEIGHT: 3.67 lbs
8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

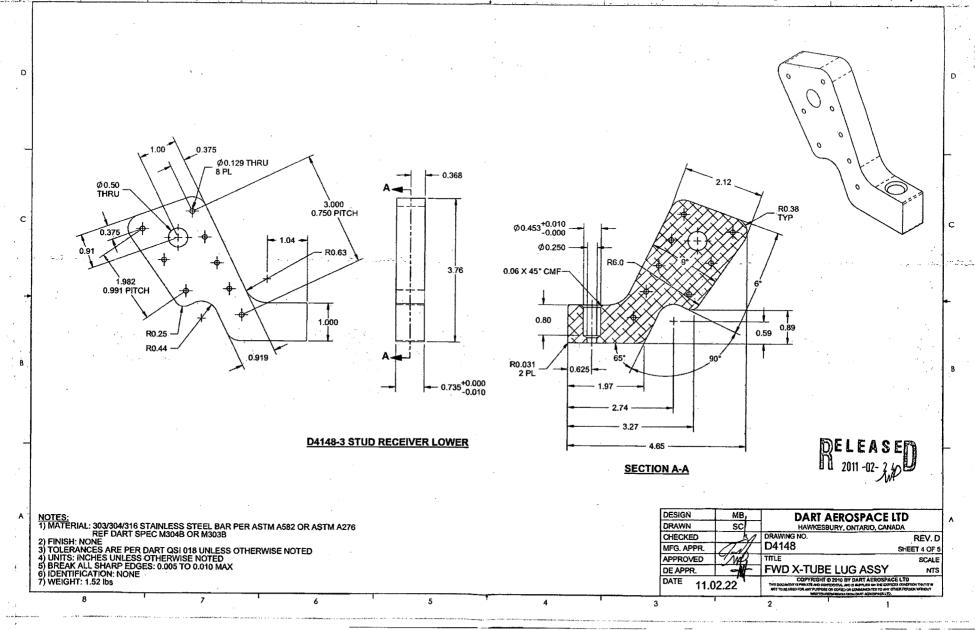
	4			.1	the second secon
		ITEM	QTY -041	P/N	DESCRIPTION
			X	D4148-041	FWD X-TUBE LUG ASSY
		1	1	D2690-6	LANYARD
		2	1	D3910-1	X-TUBE LUG
		_ 3	1	D4091-1	MOUNTING LUG
		_ 4	2	D4148-1	FWD X-TUBE LUG PLATE
	1	5	1	D4148-3	STUD RECEIVER LOWER
	-	6	1	D4148-5	EYEBOLT STUD
		7	2	AN3C12A	BOLT
Λ	\vdash	8	3	AN4C13A	BOLT
<u>₼</u> -	1	9	1	MS17984-C413	PIP PIN
		10	8	MS20615-4M18	RIVET
		11	2	MS21043C3	NUT
	\vdash	12	3	MS21043C4	NUT
		13	4	NAS1149C0332R	WASHER
	<u></u>	14	6	NAS1149C0432R	WASHER

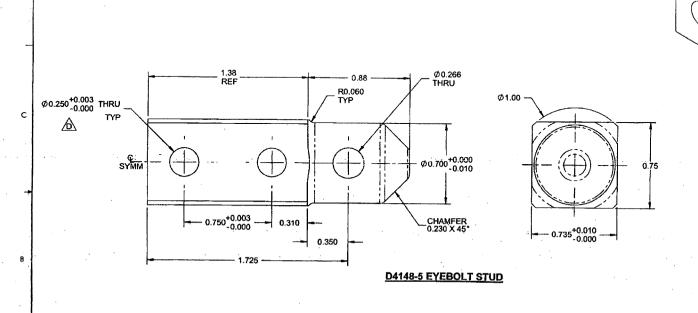
13-04-25 DELEASED

			•		
D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED DTY2) ANY3C12A, MS21043C3 AND GTY4) ANS1149C0332R WITH GTY(2) AN4C13A, MS21043C4 AND GTY4) NAS1149C043ZR (U3-1)-(C4-2)				
С	REDESIGNED D4148-1/-3 TO ADDRESS COMPATIBILITY M8 10.10.12 ISSUES WITH D350-591 SHORT STEPS				
В	REPLACED OTY(3) MS20615-4M18 WITH OTY(2) EACH AN3C17A, MS21045-3 AND OTY(4) NS41149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (FN D3-1 & B7-2); Ø0.1912 PL REPLACES MS20615-4M20 (FN D3-1 & B7-2); Ø0.1912 PL REPLACES MB 10.07.05 90.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-0350-067-2 REV. B.				
Α	NEW ISSUE			MB	10.06.18
REV.	DESCRIPTION BY			DATE	
DESIGN ME		MB	DART AEROSPACE LTD		ſD .
DRAWN		sc	HAWKESBURY, ONTAR		
CHECKED		1	DRAWING NO.		REV. D
MFG, APPR.		(2/1	7 D4148		SHEET 1 OF 5
APPROVED		JUB	TITLE		SCALE
DE APPR.		4	FWD X-TUBE LUG A	SSY	NTS
DATE 11.02.22			COPYRIGHT © 2010 BY DART THE DOCUMENT REPRAIR AND COMPONION AND IS CUPTURE INC. TO SE USED FOR ANY PURPOSE OR COMPENS OR COMPANY	DOING DAMES	CONCORDINATION









NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276 REF DART SPEC M304B OR M303B
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	sc	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1 1	DRAWING NO. REV. I	
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